

Work Order ID 77438

December-07-11 7:45:27 AM

77438

Page 1

Item ID: D4095-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.D.

Date: 11/12/07

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-1)

3.4.063

Dwg Rev: 8

Prog Rev: 5

2-Deburr if necessary

B.11-12-8

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B.11-12-8

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8.11.2007

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77438

December-07-11 7:45:27 AM

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Page 2

Item ID: D4095-041

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

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Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D4095

150

150

Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch/11/20028

Large Fab

Memo

0.00

YBL 12-01-05 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 77438

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Page 3

Item ID: D4095-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 07/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

Srdalor

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Srdalor

(12)

180

0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 119947

m/1/12 12-01-05

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77438

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Page 4

Item ID: D4095-041
Revision ID:
Item Name: Wearplate Assembly

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Start Date: 07/12/2011 Start Qty: 6.00
Required Date: 21/12/2011 Req'd Qty: 6.00

6***6***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

8C 12-01-06

200

Identify as per dwg & Stock Location: **FP 1**

0.00

200

Packaging

Memo

0.00

Packaging

12/1/06 20

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/1/06
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-07-11 7:45:31 AM

Page 1

Work Order ID: 77438

77438

Parent Item: D4095-041

D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 07/12/2011

Required Date: 21/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	237.6000	2.275	14.36842	18.5		
M304S16GA										**			
304/316 Sheet .063										18.5 - 9			

Location

Loc Qty

Loc Code

MAT020

237.6

119653

237.6

119653

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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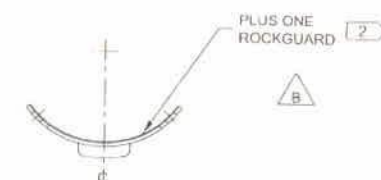
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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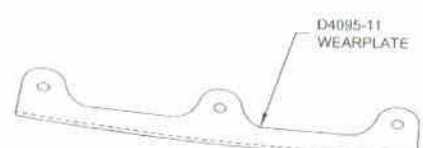
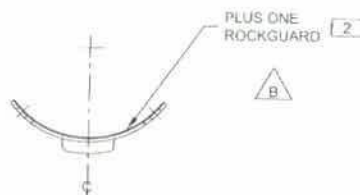
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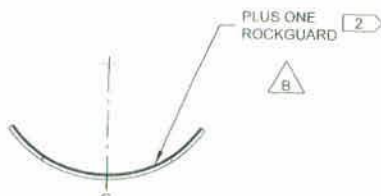
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-31
WJP

DESIGN	XDF	DART AEROSPACE USA, INC	
DRAWN		KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 2 OF 8
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DE APPR.		WEARPLATE	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

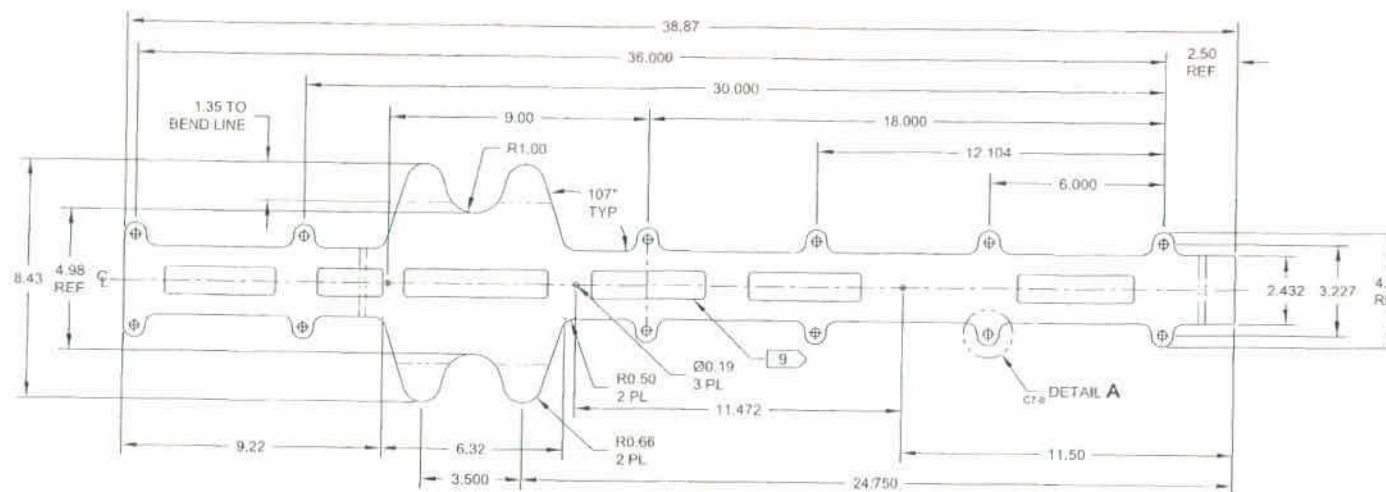
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

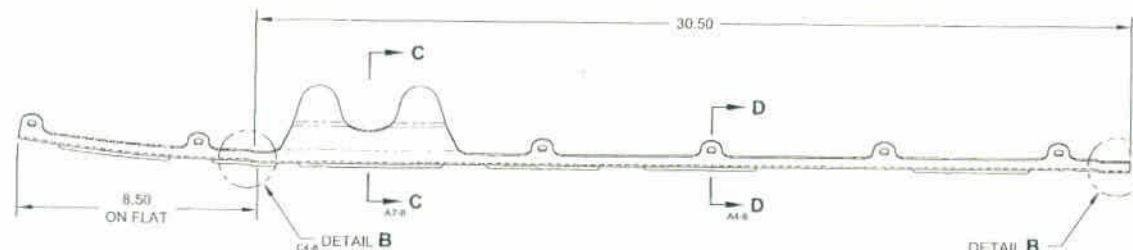
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77430



D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1F/3F/5F/7F/9F/11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

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DE APPR.	10	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC	

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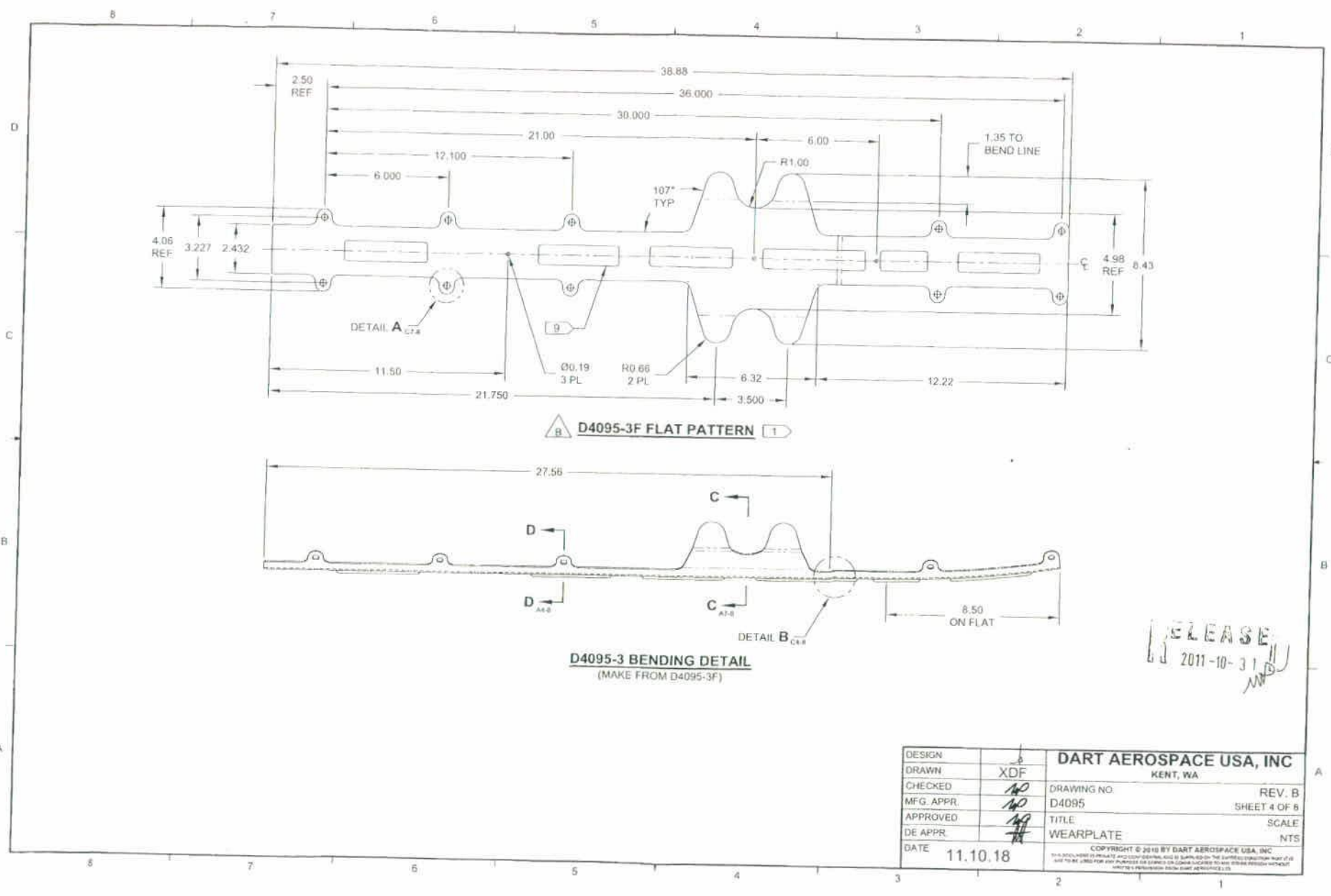
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

27438



RELEASE
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	40	DRAWING NO.	REV. B
MFG. APPR.	40	D4095	SHEET 4 OF 6
APPROVED	40	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

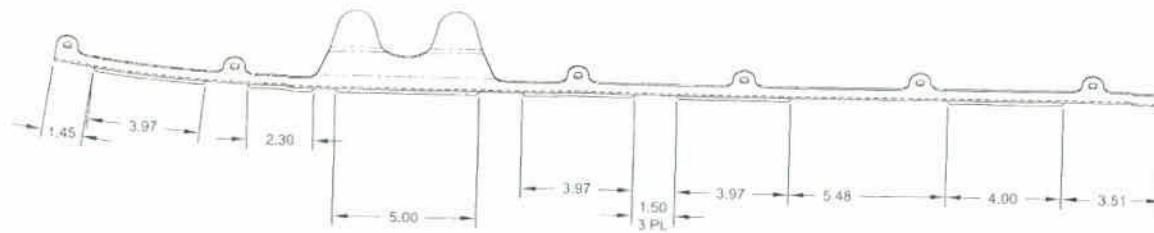
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

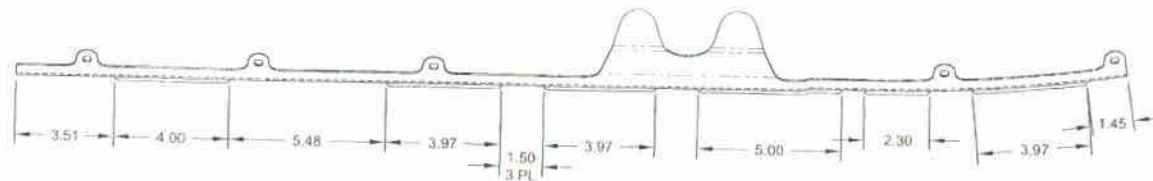
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77438



D4095-1 WELDING DETAIL



D4095-3 WELDING DETAIL



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2011-10-31
MP

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DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 5 OF 8
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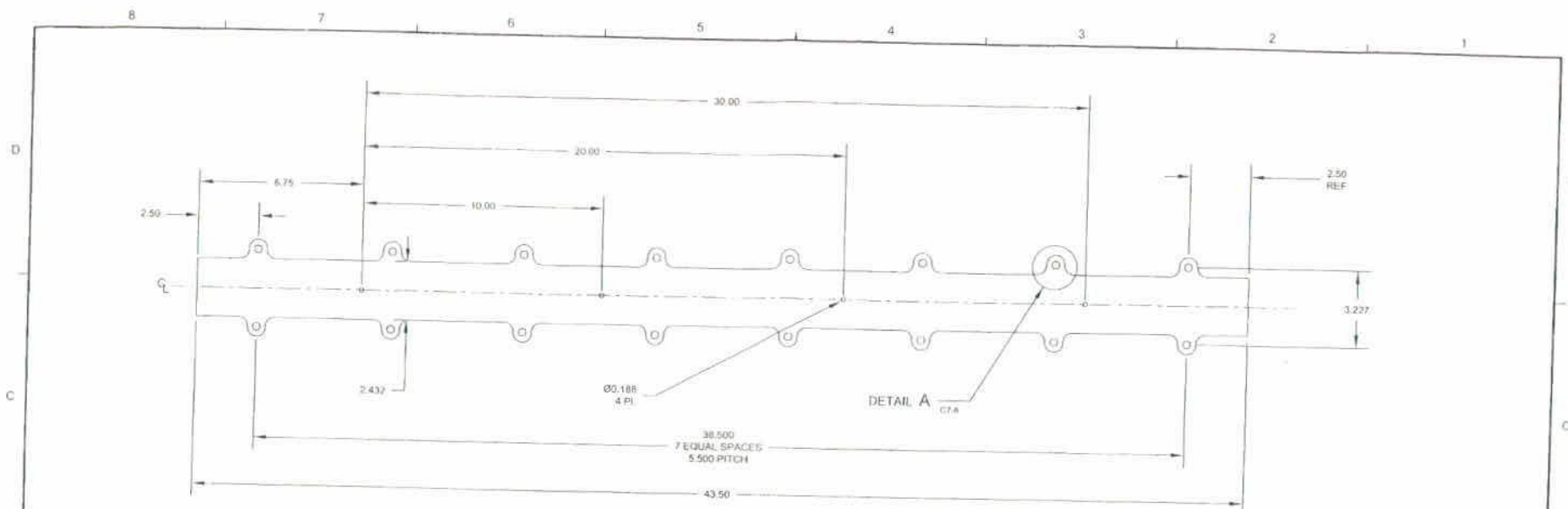
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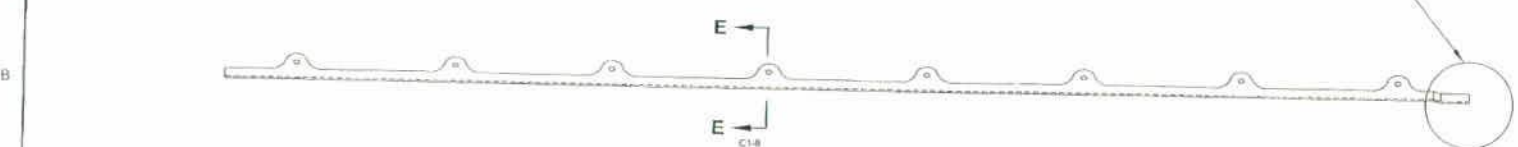
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77430



D4095-5F FLAT PATTERN



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RECEIVED
2011-10-31
NTP

DESIGN	XDF	DART AEROSPACE USA, INC KENT, WA	
DRAWN	140	DRAWING NO.	REV. B
CHECKED	140	D4095	SHEET 6 OF 8
MFG. APPR.	140	TITLE	SCALE
APPROVED	140	WEARPLATE	NTS
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W/O:		WORK ORDER CHANGES					
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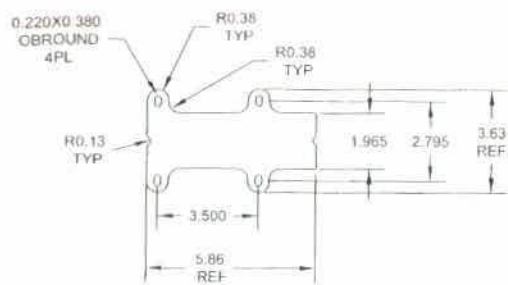
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

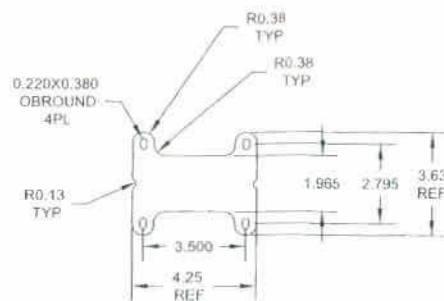
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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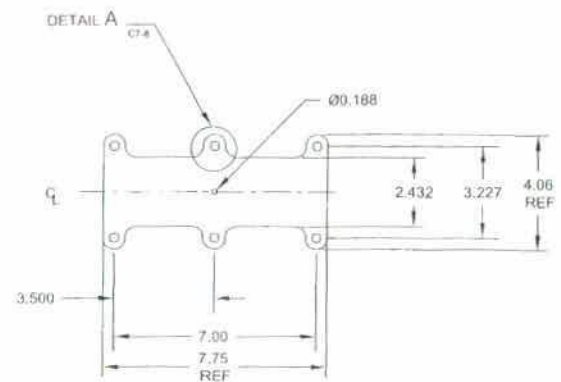
27438



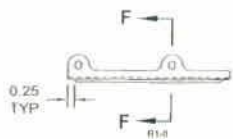
D4095-7F FLAT PATTERN



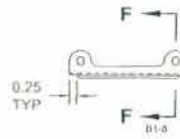
D4095-9F FLAT PATTERN



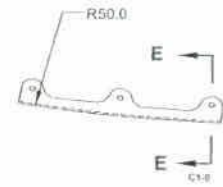
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	NO	D4095	SHEET 7 OF 8
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2011-10-31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77438
Description: Wearplate		Part Number: D4095-1
Inspection Dwg: D4095	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	193	2		✓ [B2]	
0.300	+/-0.010	303	x		✓	
0.300	+/-0.010	303	x		✓	
2.432	+/-0.010	2436	2		✓	
3.227	+/-0.010	3227	2		✓	
4.06	+/-0.030	4054	2		✓	
4.98	+/-0.030	4987	x		✓	
8.43	+/-0.030	8435	2		✓ [B1]	
9.22	+/-0.030	922	2		✓	
3.500	+/-0.010	3500	2		✓	
24.750	+/-0.010	24750	2		✓	
11.50	+/-0.030	1150	2		✓	
11.472	+/-0.010	11472	2		✓	
6.000	+/-0.010	6000	2		✓	
12.104	+/-0.010	12104	x		✓	
18.000	+/-0.010	18000	2		✓	
30.000	+/-0.010	30000	2		✓	
9.00	+/-0.030	9000	2		✓	
36.000	+/-0.010	36000	2		✓	
38.87	+/-0.030	3887	2		✓	
2.50	+/-0.030	250	x		✓	
0.063	+/-0.010	63	2		✓	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-12-9	Date: 11/12/09	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries